

GREEN

Dart Aerospace Ltd.

Date: Wednesday, 9/6/2006 3:46:11 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 28447	Part Number	: D2574		
Estimate Number	: 10534	Drawing Number	: D2574 REV E		
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 9/6/2006	S.O. No.	: N/A		
Prsh Rev.	: NC	Drawing Revision	: E		
First Issue	: N/A	Material	: N/A		
Previous Run	: 27995	Due Date	: 9/13/2006		
Written By	:	Qty:	6		
Checked & Approved By	:	Um:	Each		
Comment	: Est Rev: I As Rev RevE 06-01-27 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	Barcode
1.0	D6101005	7075-T7351 8.25X5.0X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: 205350	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: 32847 Double check by: J.L. 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA Date: 56/10/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/6/2006 3:46:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 28447

Part Number: D2574

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
7.0	POWDER COATING	POWDER COATING
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
9.0	PACKAGING 1	PACKAGING RESOURCE #1
10.0	QC21	FINAL INSPECTION/W/O RELEASE

Job Completion



U 06/06/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28447
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	—	✓	—	—		
B	1.745	1.755		1.750	1.750	1.749	1.750		
C	3.495	3.505		3.508	3.506	3.498	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.005	8.005	8.005		
F	0.490	0.510		0.501	0.501	0.500	0.501		
G	0.257	0.262	DT8683	—	—	—	—		
H	0.375	0.380	DT8684	—	—	—	—		
I	0.490	0.510		0.501	0.494	0.500	0.506		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.567	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.499	2.506	2.499	2.500		
O	4.119	4.129		4.122	4.122	4.124	4.122		
P	0.115	0.135		0.121	0.122	0.122	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.253	0.253	0.252		
S	0.115	0.135		0.119	0.120	0.117	0.118		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.239	0.241	0.239		
W	0.115	0.135		0.126	0.126	0.124	0.123		
X	0.307	0.312		0.309	0.309	0.308	0.309		
Y	0.760	0.765		0.760	0.760	0.762	0.760		
Z	0.352	0.372		0.369	0.369	0.369	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.626	0.629	0.629	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.246	0.246	0.246		
AE	1.500	1.520		1.502	1.509	1.509	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.249	0.251	0.249		
AI	2.000	2.020		2.000	2.006	2.000	2.006		
AJ	0.023	0.043		0.033	0.035	0.035	0.035		
Accept/Reject									

Measured by:	OMZ	Audited by:	M8
Date:	06/09/18	Date:	06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	2019

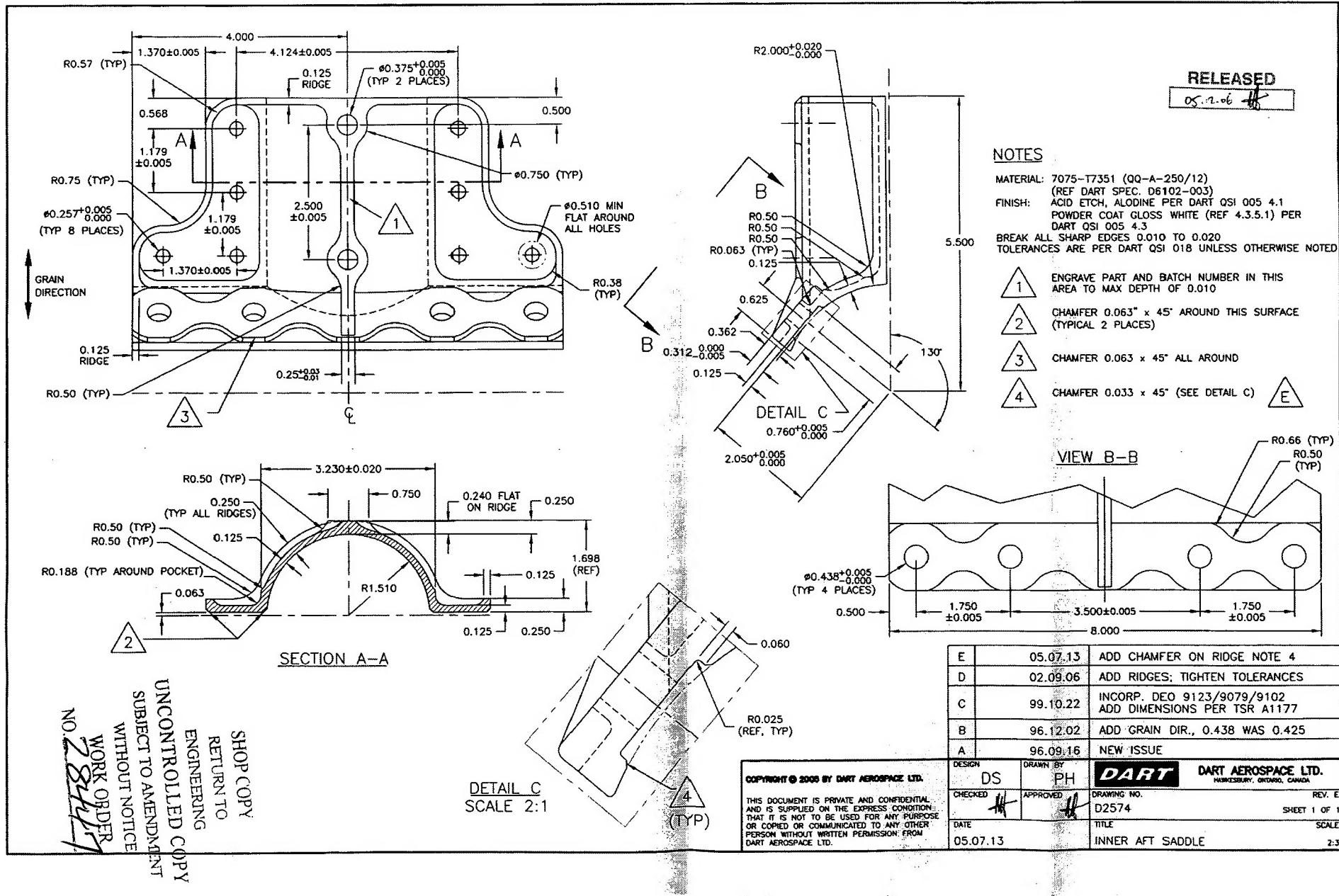
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Measured by:	<i>ml</i>	Audited by:	<i>MS</i>
Date:	06/09/18	Date:	06/09/22

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28447